



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2573**Job Sheet 209783**

Part No: D2573

Job Qty: 12 pcs

Part Name: Saddle, Aft, Out



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/8/20

Job Tracking No:

Due Date: 7/3/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV F IPP: I As Per RevE 06-01-27 JLM

Ship Via:

Bill of Materials**Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Machining - Issue SN	12 pcs	7/2/20		0.00	0.00	HAAS - 1		SBL 20/06/03
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
100	HAAS 4 Axis - B4B	12 pcs	7/2/20		1.00	19.35	HAAS - 1 - B4B		DIP 20-06-09
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
110	Conventional Mill - 1 - B4B	12 pcs	7/2/20		0.00	2.00	Conventional Mill - 1 - B4B		DIP 20-06-09
							Conventional Mill - 2 - B4B		
120	QC 2	12 pcs	7/2/20		0.00	0.00	QC 2 - 1		JL 20-6-10
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL : 1 613 632-5200
Email: sales@dartaero.com
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Container No: S281073



Part: D2573

Job No: 209783

Serial No/Batch: S281073

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 06/03/20

					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	DIP 20-06-09
					QC 2 - 69	
					QC 2 - 76	
					QC 2 - 86	
					QC 2 - 83	
130	QC 8	12 pcs	7/2/20	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	DL 20-6-10
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
					QC 8 - 66	
					QC 8 - 73	
					QC 8 - 82	
140	Handfinish - 1-1 Chemical- B4B	12 pcs	7/2/20	0.00 0.56	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 -	

				B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150	Powdercoat - 1 White GI(A)- B4B	12 pcs	7/3/20	0.00 0.46	Powdercoat - 1 - B4B
					Powdercoat - 2 - B4B
					Powdercoat - 3 - B4B
					Powdercoat - 4 - B4B
160	QC 3	12 pcs	7/3/20	0.00 0.00	QC 3 - 10
					QC 3 - 13
					QC 3 - 15
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 28
					QC 3 - 3
					QC 3 - 30
					QC 3 - 34
					QC 3 - 36
					QC 3 - 41
					QC 3 - 51
					QC 3 - 58
					QC 3 - 59
					QC 3 - 68
					QC 3 - 9
					QC 3 - 40
					QC 3 - 19
					QC 3 - 43
					QC 3 - 24
					QC 3 - 61
					QC 3 - 81
					QC 3 - 82
					QC 3 - 87
170	Packaging 3-1 - Stock - B4B	12 pcs	7/3/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B

				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
180 QC 21 - SA	12 pcs	7/3/20	0.00 0.00	QC 21 - SA - 21	JUN 17 2020
				QC 21 - SA - 70	
				QC 21 - SA - 53	

DAS

77

9-89

Part Op 100 - (HAAS CNC vertical machine #1) Program Batch No. 1181073
 Descriptions: 110 - (Manufacture as per dwg) Machine keyway as per dwg D2573 & D2574
 120 - QC2- Inspect parts off machine FAI/FAIB
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1) 1176464
 150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: 2.40 Q.T. 320° FINISH: 3.10.
 160 - (QC3- Inspect Part Finish)
 170 - (Identify as per dwg & Stock Location: _____)
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-007	Saddle Billet	12 pcs (1 ea)	90-Machining - Issue SN	<u>8268583</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Machining - Issue SN	D6101-007	12	31	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Aft Outboard	0.438Inches	+ 0.005 - 0.000	0.443 0.438	
2	Saddle, Aft Outboard	1.745Inches	+ 0.010 - 0.000	1.755 1.745	
3	Saddle, Aft Outboard	3.495Inches	+ 0.010 - 0.000	3.505 3.495	
4	Saddle, Aft Outboard	1.745Inches	+ 0.010 - 0.000	1.755 1.745	

5	Saddle, Aft Outboard	7.990Inches	+ 0.020 - 0.000	8.010 7.990
6	Saddle, Aft Outboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
7	Saddle, Aft Outboard	0.257Inches	+ 0.005 - 0.000	0.262 0.257
8	Saddle, Aft Outboard	0.375Inches	+ 0.005 - 0.000	0.380 0.375
9	Saddle, Aft Outboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
10	Saddle, Aft Outboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
11	Saddle, Aft Outboard	0.558Inches	+ 0.020 - 0.000	0.578 0.558
12	Saddle, Aft Outboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
13	Saddle, Aft Outboard	1.365Inches	+ 0.010 - 0.000	1.375 1.365
14	Saddle, Aft Outboard	2.495Inches	+ 0.010 - 0.000	2.505 2.495
15	Saddle, Aft Outboard	4.119Inches	+ 0.010 - 0.000	4.129 4.119
16	Saddle, Aft Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
17	Saddle, Aft Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
18	Saddle, Aft Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
19	Saddle, Aft Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
20	Saddle, Aft Outboard	0.178Inches	+ 0.020 - 0.000	0.198 0.178
21	Saddle, Aft Outboard	3.210Inches	+ 0.040 - 0.000	3.250 3.210
22	Saddle, Aft Outboard	0.230Inches	+ 0.020 - 0.000	0.250 0.230
23	Saddle, Aft Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
24	Saddle, Aft Outboard	0.308Inches	+ 0.005 - 0.000	0.313 0.308
25	Saddle, Aft Outboard	0.760Inches	+ 0.005 - 0.000	0.765 0.760
26	Saddle, Aft Outboard	0.352Inches	+ 0.020 - 0.000	0.372 0.352
27	Saddle, Aft Outboard	0.470Inches	+ 0.060 - 0.000	0.530 0.470
28	Saddle, Aft Outboard	0.615Inches	+ 0.020 - 0.000	0.635 0.615
29	Saddle, Aft Outboard	0.053Inches	+ 0.020 - 0.000	0.073 0.053
30	Saddle, Aft Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
31	Saddle, Aft Outboard	1.500Inches	+ 0.020 - 0.000	1.520 1.500
32	Saddle, Aft Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
33	Saddle, Aft Outboard	0.240Inches	+ 0.040 - 0.000	0.280 0.240
34	Saddle, Aft Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
35	Saddle, Aft Outboard	2.000Inches	+ 0.020 - 0.000	2.020 2.000
36	Saddle, Aft Outboard	0.023Inches	+ 0.020 - 0.000	0.043 0.023

Plex 5/8/20 1:15 PM Dart.lajeunesse.marie

DART AEROSPACE LTD	Work Order: 209783
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.440	0.440	0.440	0.440		
B	1.745	1.755		1.7445	1.750	1.750	1.750		
C	3.495	3.505		3.4975	3.500	3.500	3.500		
D	1.745	1.755		1.748	1.750	1.749	1.749		
E	7.990	8.010		8.000	8.002	8.003	8.002		
F	0.490	0.510		0.5015	0.503	0.501	0.503		
G	0.257	0.262		0.258	0.259	0.259	0.258		
H	0.375	0.380		0.377	0.377	0.378	0.377		
I	0.490	0.510		0.5035	0.503	0.502	0.501		
J	1.174	1.184		1.181	1.181	1.180	1.180		
K	0.558	0.578		0.568	0.568	0.569	0.570		
L	1.174	1.184		1.1815	1.179	1.180	1.180		
M	1.365	1.375		1.371	1.371	1.366	1.368		
N	2.495	2.505		2.493	2.493	2.500	2.499		
O	4.119	4.129		4.125	4.125	4.125	4.125		
P	0.115	0.135		0.135	0.135	0.135	0.135		
Q	0.115	0.135		0.125	0.125	0.126	0.126		
R	0.240	0.260		0.249	0.250	0.250	0.250		
S	0.115	0.135		0.125	0.126	0.128	0.126		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.2275	3.230	3.229	3.231		
V	0.230	0.250		0.245	0.240	0.240	0.240		
W	0.115	0.135		0.130	0.128	0.128	0.127		
X	0.308	0.313		0.310	0.311	0.312	0.312		
Y	0.760	0.765		0.763	0.763	0.763	0.763		
Z	0.352	0.372		0.361	0.363	0.362	0.362		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.633	0.628	0.629	0.629		
AC	0.053	0.073		0.060	0.061	0.063	0.063		
AD	0.240	0.260		0.255	0.249	0.249	0.249		
AE	1.500	1.520		1.510	1.511	1.511	1.512		
AF	0.115	0.135		0.120	0.125	0.128	0.128		
AG	0.240	0.280		0.255	0.255	0.259	0.254		
AH	0.240	0.260		0.250	0.250	0.249	0.250		
AI	2.000	2.020		2.000	2.001	2.002	2.002		
AJ	0.023	0.043		0.023	0.025	0.025	0.025		

Accept/Reject

Measured by: 989
Date: 20/06/07

Audited by: JJ
Date: 20-6-10

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 205783
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				54	62	78	84		
A	0.438	0.443		0.439	0.439	0.439	0.439		
B	1.745	1.755		1.749	1.749	1.749	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.003	8.001	8.002	8.002		
F	0.490	0.510		0.504	0.503	0.497	0.502		
G	0.257	0.262		0.258	0.258	0.258	0.258		
H	0.375	0.380		0.376	0.376	0.376	0.376		
I	0.490	0.510		0.502	0.502	0.502	0.502		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.568	0.568	0.570	0.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.369	1.369	1.369	1.369		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.135	0.135	0.135	0.135		
Q	0.115	0.135		0.123	0.124	0.125	0.125		
R	0.240	0.260		0.248	0.249	0.250	0.249		
S	0.115	0.135		0.126	0.127	0.125	0.127		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.239	0.240	0.240	0.239		
W	0.115	0.135		0.126	0.127	0.127	0.125		
X	0.308	0.313		0.313	0.311	0.311	0.310		
Y	0.760	0.765		0.763	0.763	0.763	0.763		
Z	0.352	0.372		0.366	0.365	0.364	0.363		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.626	0.626	0.623	0.628		
AC	0.053	0.073		0.065	0.065	0.065	0.065		
AD	0.240	0.260		0.249	0.249	0.249	0.249		
AE	1.500	1.520		1.512	1.511	1.512	1.512		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.250	0.260	0.260	0.260		
AH	0.240	0.260		0.250	0.249	0.248	0.248		
AI	2.000	2.020		2.002	2.000	2.002	2.002		
AJ	0.023	0.043		0.025	0.025	0.025	0.025		

Accept/Reject

Measured by: DTP	Audited by: JL
Date:	Date: 20-06-09

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 209783
Description: Saddle Aft outboard		Part Number: D2573
Inspection Dwg: D2573	Rev: C	DSK: Rev: Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				9*	102	113	124	5
A	.438	.443		0.439	0.439	0.439	0.439	
B	1.745	1.755		1.750	1.750	1.750	1.750	
C	3.495	3.505		3.500	3.500	3.500	3.500	
D	1.745	1.755		1.750	1.750	1.750	1.750	
E	7.990	8.010		8.002	8.002	8.002	8.002	
F	0.490	0.510		0.502	0.505	0.502	0.505	
G	0.257	0.262		0.258	0.258	0.258	0.258	
H	0.375	0.380		0.376	0.376	0.376	0.376	
I	0.490	0.510		0.503	0.507	0.505	0.505	
J	1.174	1.184		1.180	1.180	1.179	1.179	
K	0.558	0.578		0.570	0.572	0.570	0.570	
L	1.174	1.184		1.179	1.179	1.179	1.179	
M	1.365	1.375		1.370	1.370	1.370	1.370	
N	2.495	2.505		2.500	2.500	2.500	2.500	
O	4.119	4.129		4.124	4.124	4.124	4.124	
P	0.115	0.135		0.130	0.127	0.128	0.129	
Q	0.115	0.135		0.126	0.126	0.125	0.125	
R	0.240	0.260		0.251	0.250	0.250	0.250	
S	0.115	0.135		0.125	0.127	0.126	0.126	
T	0.178	0.188		0.188	0.188	0.188	0.188	
U	3.210	3.250		3.230	3.220	3.220	3.230	
V	0.230	0.250		0.240	0.239	0.240	0.240	
W	0.115	0.135		0.125	0.130	0.126	0.126	
X	0.308	0.313		0.310	0.309	0.309	0.309	
Y	0.760	0.765		0.763	0.763	0.763	0.763	
Z	0.352	0.372		0.363	0.364	0.365	0.365	
AA	0.470	0.530		0.500	0.500	0.500	0.500	
AB	0.615	0.635		0.628	0.628	0.628	0.625	
AC	0.053	0.073		0.065	0.060	0.060	0.060	
AD	0.240	0.260		0.250	0.249	0.248	0.249	
AE	1.500	1.520		1.512	1.510	1.510	1.510	
AF	0.115	0.135		0.130	0.130	0.128	0.129	
AG	0.240	0.280		0.270	0.270	0.270	0.270	
AH	0.240	0.260		0.250	0.247	0.248	0.249	

Accept/Reject

Measured by: DJD	Date: 20-06-09
Audited by: JL	Date: 20-6-10
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.11.08	Reformat	KJ/JLM	
C	12.07.31	Prototype revised to preliminary	KJ	

AI 2.000 | 2.020 | 2.002 | 2.000 | 2.000 | 2.000 |
 AJ 0.023 | 0.043 | 0.030 | 0.030 | 0.030 | 0.030 |

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					